



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4079-1

Job Sheet 184301



Part No: D4079-1

Job Qty: 10 ea

DAS

21

9-89

Part Name: Clamp Half, Attachment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/5/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Machining-2		SBZ 18/10/23
100	Bandsaw	10 pcs	10/19/18	10/19/18	0.00	0.69	Bandsaw1		SBZ 18/10/23
110	CNC Vertical Machining	10 pcs	10/19/18	10/19/18	0.22	7.09	HAAS1-4		SBZ 18/10/23
130	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC8 Machining-2		SBZ 18/10/23
140	HandFinish	10 pcs	10/19/18	10/19/18	0.00	0.34	HandFinish1		DR 18/10/23
150	Powdercoat	10 pcs	10/19/18	10/19/18	0.00	0.18	Powdercoat4		DR 18/10/23
160	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC3		DR 18/10/23
170	Packaging	10 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2		DR 18/10/23
180	QC21-SA	10 Ea	10/19/18	10/19/18	0.00	0.00	QC21		DR 18/10/23

Part Op 100 - Cut blank 2.750" long
Descriptions: 110 - Mill as per Dwg and Folio FA931 Dwg Rev: _____

DAS

21

9-89

OCT 30 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	2.3000 ft (.23 ea)	90-Start up Operation	5115943

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X02.000	2	20	0

M138839 START: 9:15 TEMP: 320° FINISH: 9:45

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp Half, Attachment	2.502Inches ± 0.010	2.512 2.492	2.502	
2	Clamp Half, Attachment	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	0.203
3	Clamp Half, Attachment	0.750Inches ± 0.030	0.780 0.720	0.746	
4	Clamp Half, Attachment	0.375Inches ± 0.010	0.385 0.365	0.375	
5	Clamp Half, Attachment	0.310Inches ± 0.010	0.320 0.300	0.309	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																																						
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																																				
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																																				
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																																				
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: \$120527 Part: D4079-1 Job No: 184301 Serial No/Batch: \$120527 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/23/18				Completed By																																																																																																																																						
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6	Clamp Half, Attachment	1.882Inches $\pm$ 0.010	1.892 1.872	1.882
7	Clamp Half, Attachment	0.780Inches $\pm$ 0.030	0.810 0.750	0.781
8	Clamp Half, Attachment	0.130Inches $\pm$ 0.030	0.160 0.100	Radius 0.125
9	Clamp Half, Attachment	1.440Inches $\pm$ 0.010	1.450 1.430	1.440
10	Clamp Half, Attachment	0.380Inches $\pm$ 0.010 - 0.000	0.390 0.380	Radius 0.386
11	Clamp Half, Attachment	0.050Inches $\pm$ 0.010	0.060 0.040	Radius 0.050
12	Clamp Half, Attachment	0.730Inches $\pm$ 0.010	0.740 0.720	Radius 0.730
13	Clamp Half, Attachment	0.257Inches $\pm$ 0.030	0.287 0.227	Diameter 0.257
14	Clamp Half, Attachment	0.250Inches $\pm$ 0.006 - 0.001	0.256 0.249	Radius 0.250
15	Clamp Half, Attachment	0.390Inches $\pm$ 0.030	0.420 0.360	0.392
16	Clamp Half, Attachment	0.850Inches $\pm$ 0.010	0.860 0.840	0.850
17	Clamp Half, Attachment	0.025Inches $\pm$ 0.010	0.035 0.015	0.030
18	Clamp Half, Attachment	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45°
19	Clamp Half, Attachment	0.100Inches $\pm$ 0.010	0.110 0.090	0.101
20	Clamp Half, Attachment	0.050Inches $\pm$ 0.030	0.080 0.020	Radius 0.0625
21	Clamp Half, Attachment	1.240Inches $\pm$ 0.010	1.250 1.230	1.240
22	Clamp Half, Attachment	1.650Inches $\pm$ 0.030	1.680 1.620	0.6005
23	Clamp Half, Attachment	0.600Inches $\pm$ 0.030	0.630 0.570	1.653
24	Clamp Half, Attachment	0.230Inches $\pm$ 0.030	0.260 0.200	0.227
25	Clamp Half, Attachment	0.025Inches $\pm$ 0.010	0.035 0.015	0.025

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								